

Work Order ID 75468

October-24-11 10:16:50 AM

75468

Page 1

Item ID: D3067-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: End Plate
 Start Date: 24/10/2011 Start Qty: 60.00 ***60*** Cust Item ID:
 Required Date: 28/10/2011 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/24 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3067 | Rev A |

| | | | | | | | | | |
|-----|----------------|------|--|--|--|--|--|--|--|
| 100 | FLOW WATER JET | 0.00 | | | | | | | |
|-----|----------------|------|--|--|--|--|--|--|--|

100
 Waterjet
 FLOW CNC Waterjet
 5052 063

Memo
 1-Cut as per Dwg D3067
 Dwg Rev: 1
 Prog Rev: 1
 2-Deburr if necessary

11-10-29 96

11-10-26
 11-10-31

96

| | | | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|

110
 QC
 Quality Control

Memo

11-10-25
 11-10-31

11-10-25

| | | | | | | | | | |
|-----|-----------------------------------|------|--|--|--|--|--|--|--|
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
|-----|-----------------------------------|------|--|--|--|--|--|--|--|

120
 QC
 Quality Control

Memo

11 10 30

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D30677 PAR #: N/A Fault Category: Water Jet small FAD. NCR: Yes No QA: 11-11-03 Date: 11-11-03
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: 11-11-03 Date: 11-11-03

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) $2.30 \times 96 = 220.80$ | | | | | | |
|----------|------|---|-----------------------------|--|-----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 11/10/28 | #100 | Found at inspection that parts were cut with the wrong direction of the grain to day. | <u>AS</u> | → SCRAP ALL QM (+96) Replane with correct grain M1116322 | <u>11-11-03</u> | <u>11/11/01</u> | <u>AS</u> | <u>11/10/28</u> |
| | | R-L LOA - operator didn't pay attention to grain (Day. Clear) | | | | | | <u>11/10/28</u> |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 75468

October-24-11 10:16:50 AM

75468

Page 2

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|----------|--------------|---------------|---------------|------------------|----------------|
| 130 | NC BRAKE | 0.00 | | | | | | | |
| *130* | | | | | | 75 | | | |
| Brake NC | Memo | 0.00 | SB | 11/10/31 | | | | | |
| Brake NC | Bend as per Dwg D3067 | | | | | | | | |
| 140 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 150 | Identify as per dwg & Stock Location: <u>W/A</u> | 0.00 | | | | | | | |
| *150* | | | | | | 75 | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | *** STOCK IN STEP CELL*** | | | | | | | | |

11.11.01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 75468***75468***

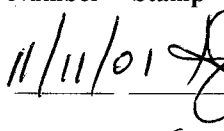
Page 3

October-24-11 10:16:50 AM

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

11/11/01 
MF
11-10-01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

October-24-11 10:16:57 AM

Page 1

Work Order ID: 75468

75468

Parent Item: D3067-1

D3067-1

Parent Item Name: End Plate

Start Date: 24/10/2011

Required Date: 28/10/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: 03.01.21 Remove step 6 (Deburr) KJ
IPP Rev:B Now on Water jet 06-06-16 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M5052H32S.063

Purchased

No

100

sf

62.5000

0.0625

3.947368

6.

M5052H32S 063

11-10-26

5052-H32 .063 Sheet

Location

Loc Qty

Loc Code

MAT022

62.5

114322

62.5

114322

11-10-31

96

66

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

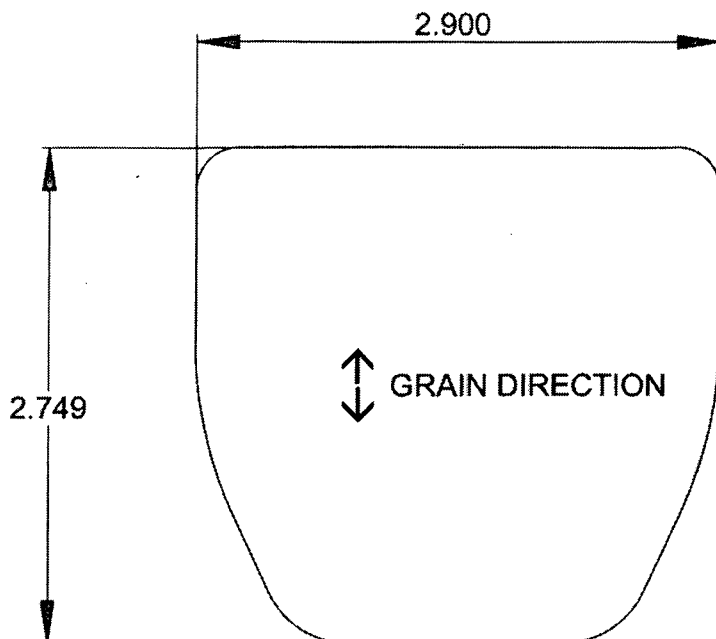
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NOTE: Date & initial all entries

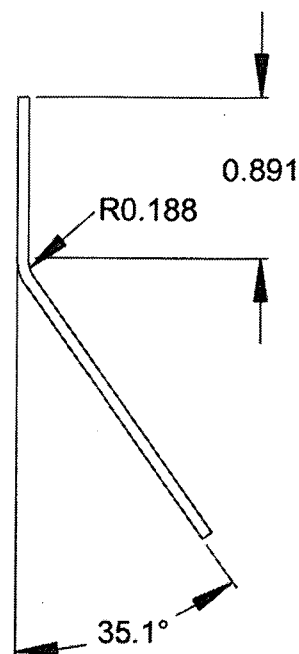


| | | | |
|-------------------------|-----------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>CP</i> | APPROVED <i>CP</i> | DRAWING NO. D3067 | REV. A SHEET 1 OF 1 |
| DATE 02.09.11 | | TITLE END PLATE | SCALE 1:1 |
| A | 02.09.11 | NEW ISSUE | |

RELEASED
02.04.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 75468 *M.C.J.*
11/10/24

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

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